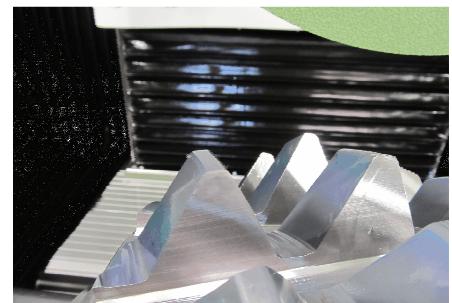
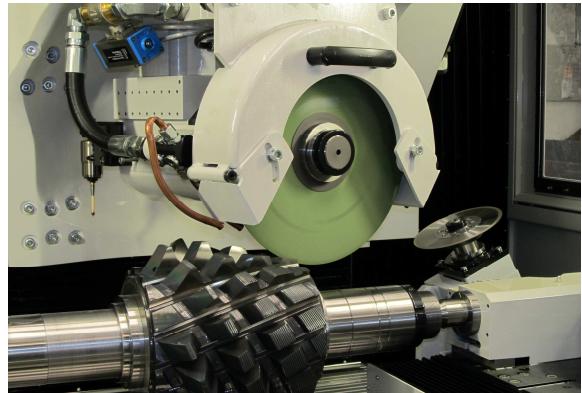
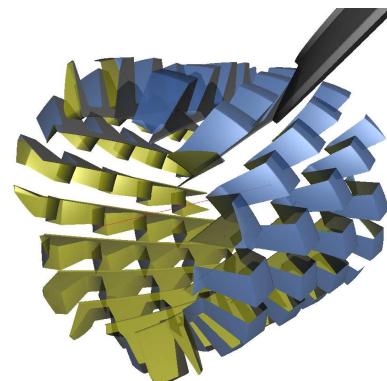


Worm Gearbox Ø280 Z15

A12-021

This worm gearbox with gash-lead of 22.7° and gash depth of 47 mm is resharpened with a dressed wheel, where a dressing takes place each 5th tooth. The calculation of the DXF-form of the wheel as well as the optimized position on the cutting face is fully automatic. The resharpening takes off 0.2 mm in 14 passes and 2 sparkout passes.



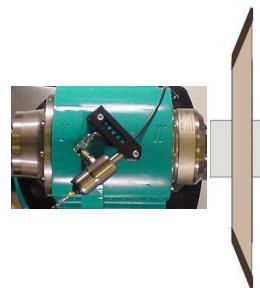
1. Cycletime for Resharpening

Workpiece:	Ø 281 mm, L 230 mm, G-Lead 1800 mm, Thr.Lead 307.7 mm Material HSS			
Operations	Probe A Pos	Dress	Gash	Index Check
Feed [mm/Min]	2000	180	4000	2000
Power [kW]		1	7	
Cutting speed [m/s]		32	32	
Used wheels				
Grinding time [s]	35	823	2207	120
Total cycle time	53 Min 6			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 1V1 Ø285 C120 DXF 25°



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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS C360 Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 31iA5 Software: Quinto 5
Accessories: Dressing, Dogdrive, Tailstock, Wheel balancing
Responsible engineer: OP. 30.4.12

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